

# Work Order ID 85123

**\*85123\***

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June-04-12 7:09:37 AM

Item ID: D2195 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Bracket  
Start Date: 6/04/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 6/04/12 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                      | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr                                  |                      |         |        |              |               |               |                  |                |
| D2195                          | Rev D   |                      |         |        |              |               |               |                  |                |
| 100                            |   | 0.00                 |         |        |              |               |               |                  |                |
| <b>*100*</b>                   |   |                      |         |        |              |               |               |                  |                |
| Small Fab                      | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Small Fab                      | ASSEMBLE AS PER DWG                           |                      |         |        |              |               |               |                  |                |
| 110                            | QC5- Inspect part completeness to step on W/O | 0.00                 |         |        |              |               |               |                  |                |
| <b>*110*</b>                   |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |
| 120                            | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  | 0.00                 |         |        |              |               |               |                  |                |
| <b>*120*</b>                   |   |                      |         |        |              |               |               |                  |                |
| Powdercoat                     | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Powder Coating                 |   |                      |         |        |              |               |               |                  |                |

change to 120019 85025  
W  
120607

12/06/04

12/06/04

**Work Order ID 85123****\*85123\***

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June-04-12 7:09:37 AM

Item ID: D2195 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Bracket  
Start Date: 6/04/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 6/04/12 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130                            | QC3- Inspect Part Finish                    | 0.00                 |         |        |              |               |               |                  |                |
| <b>*130*</b>                   |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |
| 140                            | Identify as per dwg & Stock Location: _____ | 0.00                 |         |        |              |               |               |                  |                |
| <b>*140*</b>                   |   |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      |   |                      |         |        |              |               |               |                  |                |
| 150                            | QC21- Final Inspection - Work Order Release | 0.00                 |         |        |              |               |               |                  |                |
| <b>*150*</b>                   |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |

U 120607

# Picklist Print

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Page 1

Work Order ID: 85123

Parent Item: D2195

Parent Item Name: Bracket

Start Date: 6/04/12

Required Date: 6/04/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.01.05 NEW ISSUE DD VERF:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand  | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D2195-1<br>Bracket              |                        | Manufactured  | No          |                     |                  | 100             | Each               | 3.0000          | 1           | 1            |               | 6/12/06/04     |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                 |                        |               |             | CA                  |                  | 1               |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 60928               |                  | 1               |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | Mezz                |                  | 2               |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 40763               |                  | 2               |                    |                 |             |              |               |                |        |
| D2195-2<br>Bracket              |                        | Manufactured  | No          |                     |                  | 100             | Each               | 2.0000          | 1           | 1            |               | 6/12/06/04     |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                 |                        |               |             | Mezz                |                  | 2               |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 40761               |                  | 2               |                    |                 |             |              |               |                |        |
| D2195-3<br>Spacer               |                        | Manufactured  | No          |                     |                  | 100             | Each               | 3.0000          | 1           | 1            |               | 6/12/06/04     |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                 |                        |               |             | Mezz                |                  | 1               |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 40762               |                  | 1               |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | ST005               |                  | 2               |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 60930               |                  | 2               |                    |                 |             |              |               |                |        |
| MS20470AD4-14<br>Rivet          |                        | Purchased     | No          |                     |                  | 100             | Each               | 208.0000        | 6           | 6            |               | 6/12/06/04     |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                 |                        |               |             | ST320               |                  | 208             |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 1046                |                  | 158             |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 109059              |                  | 50              |                    |                 |             |              |               |                |        |

8 7 6 5 4 3 2 1

| ITEM No. | QTY | PART NUMBER   | DESCRIPTION      |
|----------|-----|---------------|------------------|
| 1        | X   | D2195         | BRACKET ASSEMBLY |
| 7        | 1   | D2195-1       | BRACKET          |
| 8        | 1   | D2195-2       | BRACKET          |
| 9        | 1   | D2195-3       | SPACER           |
| 15       | 6   | MS20470AD4-14 | RIVET            |

W/085123

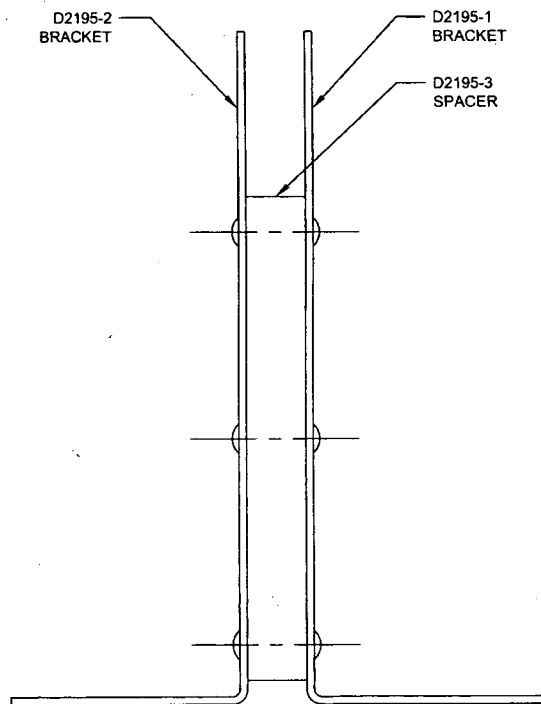
RELEASED  
27/01/13/11/18

**NOTES:**

- 1) MATERIAL:
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2195" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.26 lbs

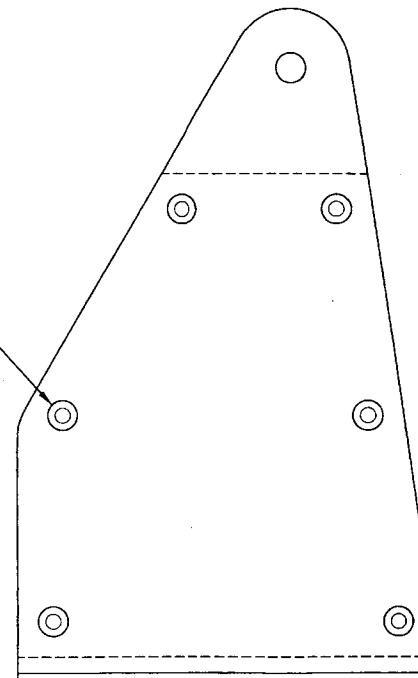
|            |                                |  |              |
|------------|--------------------------------|--|--------------|
| D          | RE-DESIGN, REF NCR 08-110.     | AJS  | 08.11.25     |
| C          | REDRAW; D2195-3 NOW 0.5" THICK | CP   | 03.05.28     |
| B          | RE-DESIGN                      | JB   | 93.09.23     |
| REV.       | DESCRIPTION                    | BY   | DATE         |
| DESIGN     | JB                             | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | AJS                            |  |              |
| CHECKED    | 1                              | DRAWING NO.  | REV. D       |
| MFG. APPR. | 2                              | D2195  | SHEET 1 OF 3 |
| APPROVED   | 3                              | TITLE  | SCALE        |
| DE APPR.   | 4                              | BRACKET  | NTS          |
| DATE       | 08.11.25                       | COPYRIGHT © 1993 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

8 7 6 5 4 3 2 1



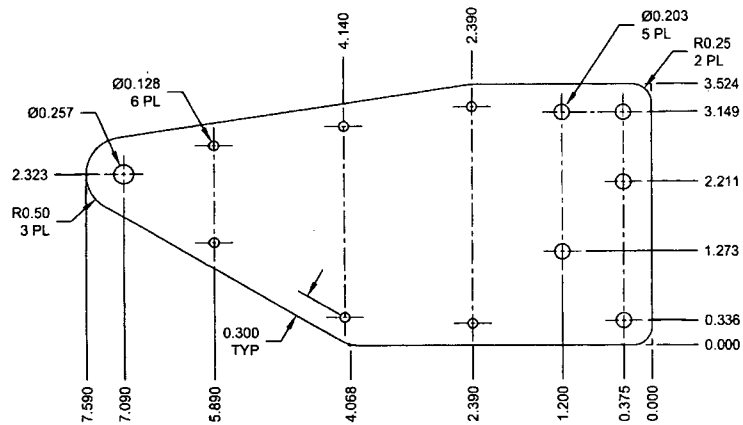
**D2195 BRACKET ASSEMBLY**

MS20470AD4-14  
RIVET  
6 PL

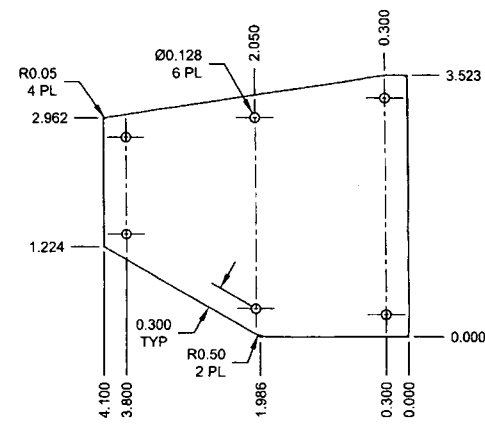


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27/01/15

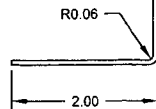
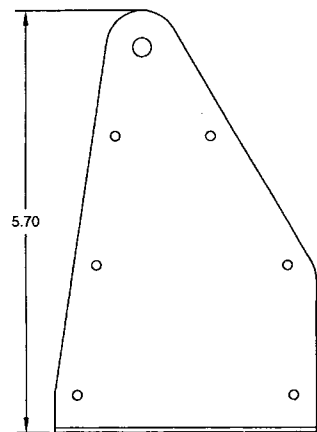
|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | JB       | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      | AJS      | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    | J        | DRAWING NO.  | REV. D       |
| MFG. APPR. | EJ       | D2195  | SHEET 2 OF 3 |
| APPROVED   | AM       | TITLE  | SCALE        |
| DE APPR.   | AM       | BRACKET  | NTS          |
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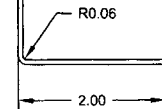
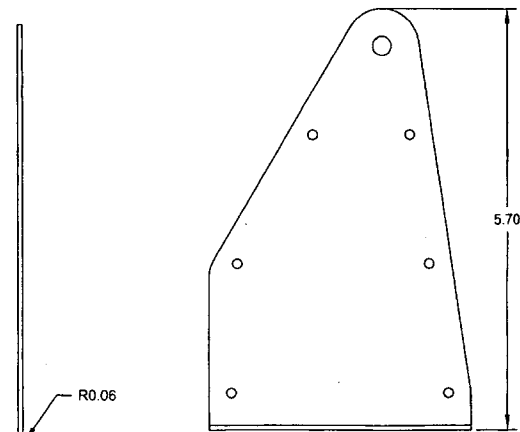
**D2195-1F BRACKET FLAT PATTERN**



**D2195-3 SPACER**



**D2195-2 BRACKET**  
MAKE FROM D2195-1F



**D2195-1 BRACKET**  
MAKE FROM D2195-1F

**NOTES:**

- 1) MATERIAL: -1 & -2: AISI 304/316 S.S. SHEET, 0.064 THICK  
PER AMS 5513 OR AMS 5524  
REF. DART SPEC M304S
- 3: 5052-H32 ALUMINUM SHEET, 0.500 THICK  
PER AMS-QQ-A-250/8 OR AMS 4016  
REF. DART SPEC M5052H32S.500
- 2) FINISH: -3 ONLY: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHT

**RELEASED**  
07/01/19

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | JB       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | AJS      |  |              |
| CHECKED    | 2        | DRAWING NO.  | REV. D       |
| MFG. APPR. | 3        | D2195  | SHEET 3 OF 3 |
| APPROVED   | 4        | TITLE  | SCALE        |
| DE APPR.   | 5        | BRACKET  | NTS          |
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# Work Order Summary

June-07-12 12:59:32 PM

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Criteria : Work Order ID: 85123 Item ID: D2195 Product Family SMALL FAB  
 Work Order Start Dates 6/04/12 to 6/04/12 11:59:59 PM Work Order Required Dates 6/04/12 to 6/04/12  
 11:59:59 PM

All References

Work Order Status Released

|                           |           |                     |        |                    |          |
|---------------------------|-----------|---------------------|--------|--------------------|----------|
| <b>Work Order ID</b>      | 85123     | <b>Required Qty</b> | 1.0000 | <b>Status Code</b> | Released |
| <b>Item ID</b>            | D2195     | <b>Accepted Qty</b> | 0.0000 | <b>Scrap Qty</b>   | 0.0000   |
| <b>Item Name</b>          | Bracket   |                     |        |                    |          |
| <b>Current Acct Value</b> | \$111.987 |                     |        |                    |          |

|                        |                     |                          |                       |                         |             |
|------------------------|---------------------|--------------------------|-----------------------|-------------------------|-------------|
| <b>Start Date</b>      | 6/04/12             | <b>Required Date</b>     | 6/04/12               | <b>Completed Date</b>   |             |
| <b>Standard</b>        | <b>** Actual **</b> | <b>** Acct. Value **</b> | <b>** Variance **</b> | <b>** Variance % **</b> |             |
| <b>Direct Costs</b>    | <b>Total</b>        | <b>Each</b>              | <b>Each</b>           | <b>Each</b>             | <b>Each</b> |
| <b>Material</b>        | \$2.897             | \$0.000                  | \$2.897               | \$2.897                 | 100.00%     |
| <b>Labor</b>           | \$14.673            | \$0.000                  | \$26.959              | \$26.959                | 100.00%     |
| <b>Outplant</b>        | \$0.000             | \$0.000                  | \$0.000               | \$0.000                 | 0.00%       |
| <b>Variable Burden</b> | \$0.000             | \$0.000                  | \$0.000               | \$0.000                 | 0.00%       |
| <b>Fixed Burden</b>    | \$38.379            | \$0.000                  | \$82.131              | \$82.131                | 100.00%     |
| <b>Material Burden</b> | \$0.000             | \$0.000                  | \$0.000               | \$0.000                 | 0.00%       |
| <b>** Total **</b>     | \$55.949            | \$0.000                  | \$111.987             | \$111.987               |             |

| Item ID/Item Name       | Required Qty | Issue Code | Issue Date | Issued Qty | Cost Amount    |
|-------------------------|--------------|------------|------------|------------|----------------|
| D2195-1<br>Bracket      | 1.0000       |            | 6/04/12    | 1.0000     | \$0.000        |
| D2195-3<br>Spacer       | 1.0000       |            | 6/04/12    | 1.0000     | \$0.000        |
| MS20470AD4-14<br>Rivet  | 6.0000       |            | 6/04/12    | 6.0000     | \$2.897        |
| <b>Total Matl Amts:</b> |              |            |            |            | <b>\$2.897</b> |

## Work Center Small Fab

| Employee ID   | Rout Seq ID | Labor Date | Setup Hours | Actual Setup Hours | Labor Hours | Actual Labor Hours | Nbr of WOs | Setup Amount | Labor Amount | Fix Burd Amount | Var Burd Amount | Total Amounts |
|---------------|-------------|------------|-------------|--------------------|-------------|--------------------|------------|--------------|--------------|-----------------|-----------------|---------------|
| BOUC02        |             |            |             |                    |             |                    |            |              |              |                 |                 |               |
| 6/04/12       |             |            |             |                    |             |                    |            |              |              |                 |                 |               |
| 100           |             |            | 0.00        | 0.00               | 0.72        | 0.72               | 1.00       | \$0.000      | \$14.673     | \$38.379        | \$0.000         | \$53.05       |
| <b>Total:</b> |             |            | 0.00        | 0.00               | 0.72        | 0.72               | 1.00       | \$0.000      | \$14.673     | \$38.379        | \$0.000         | \$53.05       |